

**D4095-1F FLAT PATTERN** 1

PRELIMINARY ISSUE

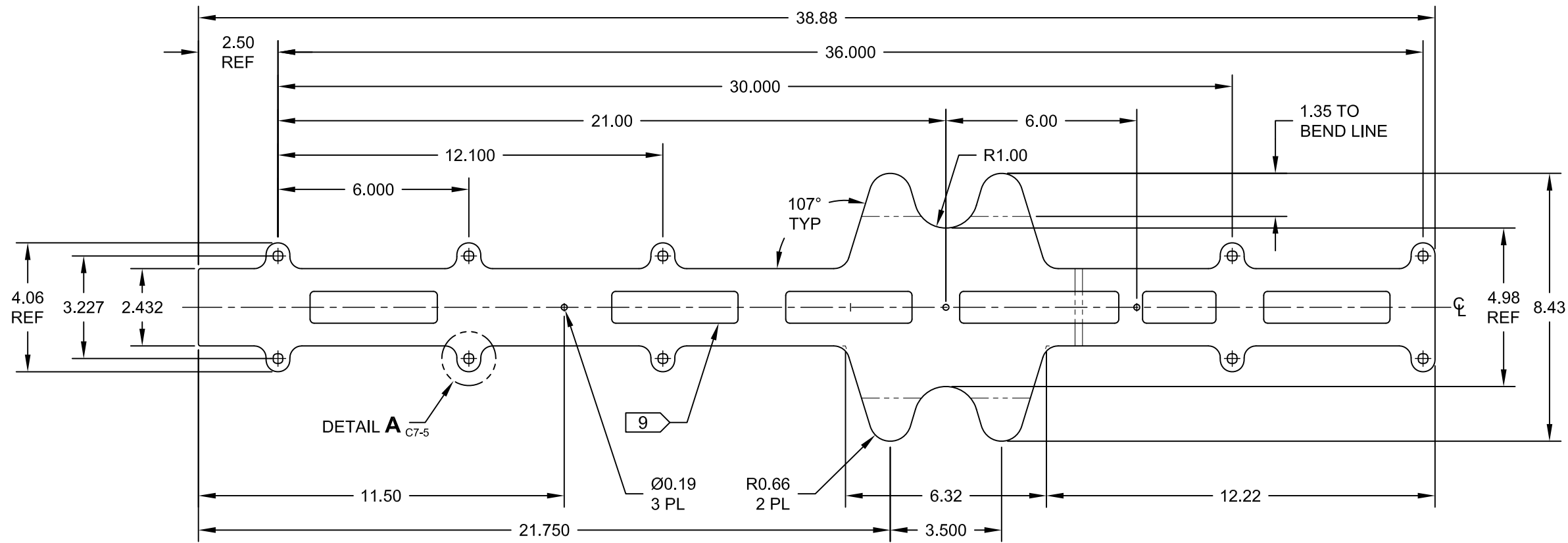
XDF 11.10.11

**D4095-1 BENDING DETAIL**  
(MAKE FROM D4095-1F)

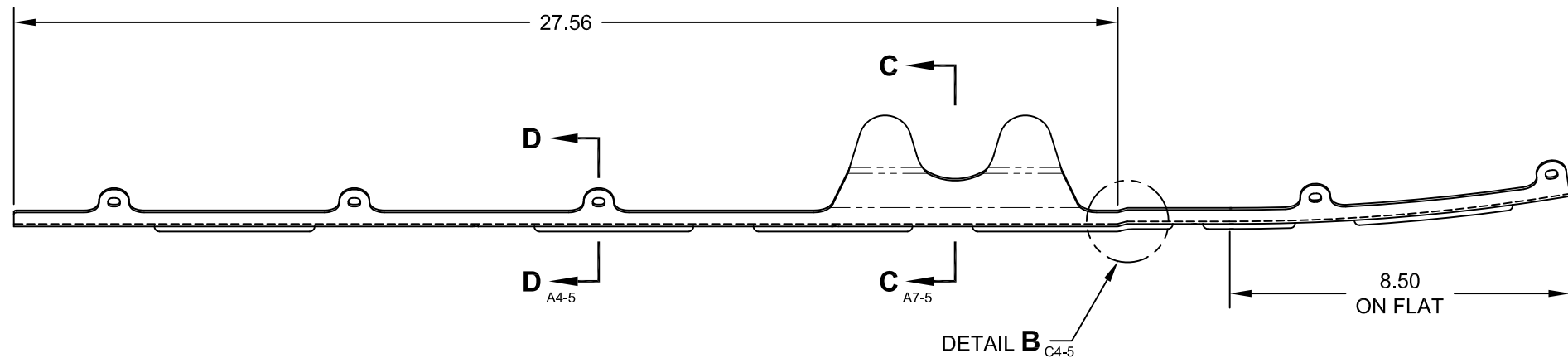
**D4095-1/-1F/-3/-3F NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240  
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 2.18 lbs; D4095-3 = 2.16 lbs
- 8) WELDING: PER DART QSI 004
- 9) 2059B HARDCOAT WELD: WELD AFTER BENDING AS ILLUSTRATED PER DT8308,  
0.13 THICK
- 10) PARTS ARE SYMMETRIC ABOUT C

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	XDF		
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4095	SHEET 2 OF 5
APPROVED		TITLE	SCALE
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**D4095-3F FLAT PATTERN** 1

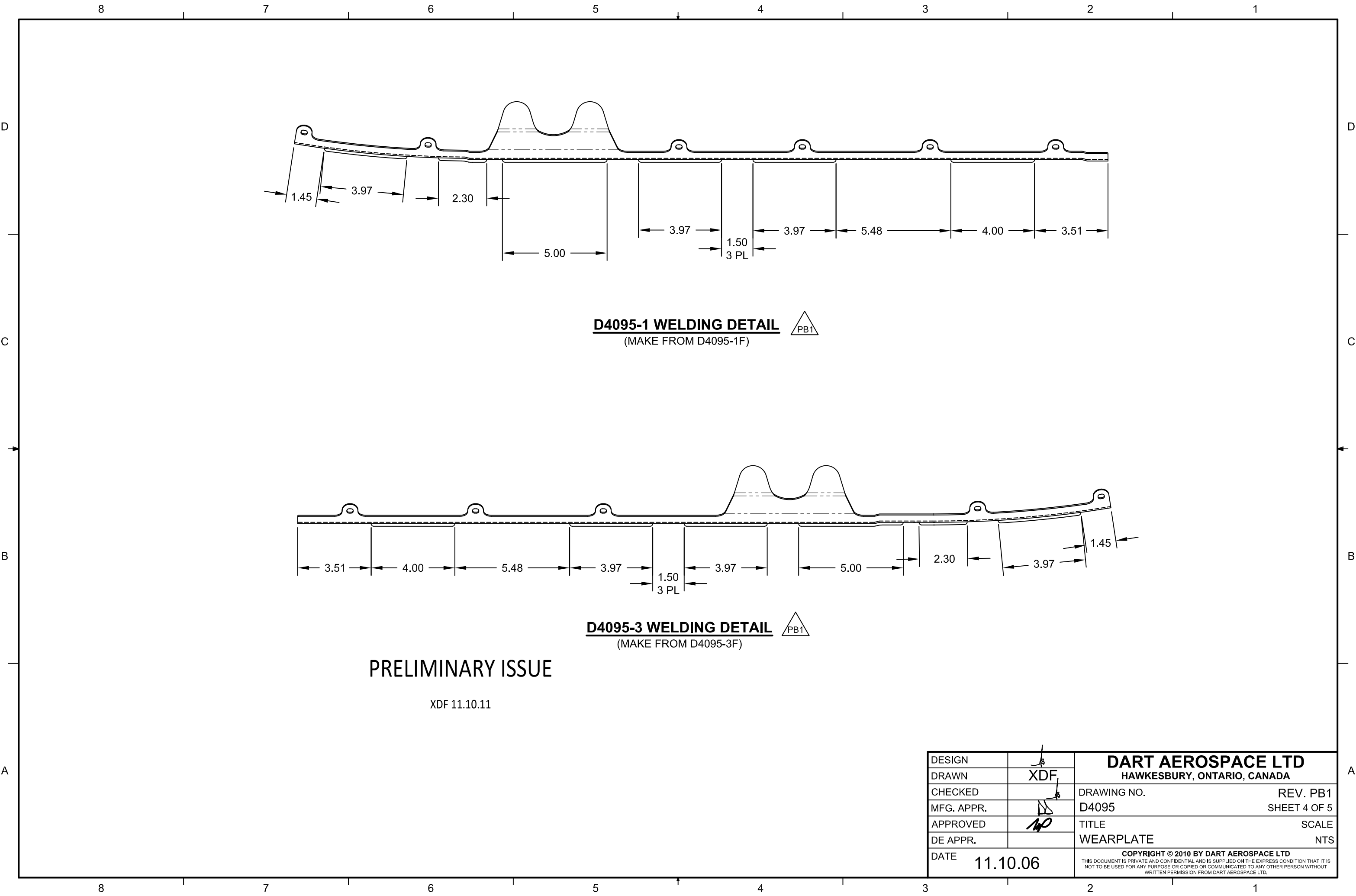


**D4095-3 BENDING DETAIL**  
(MAKE FROM D4095-3F)

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**D4095-1 WELDING DETAIL**  
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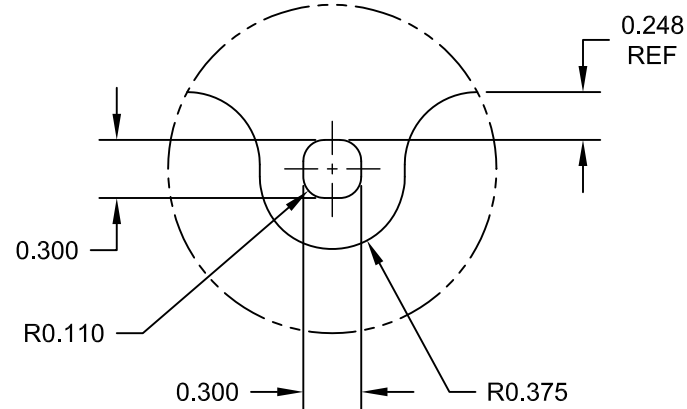
**D4095-3 WELDING DETAIL**  
(MAKE FROM D4095-3F)



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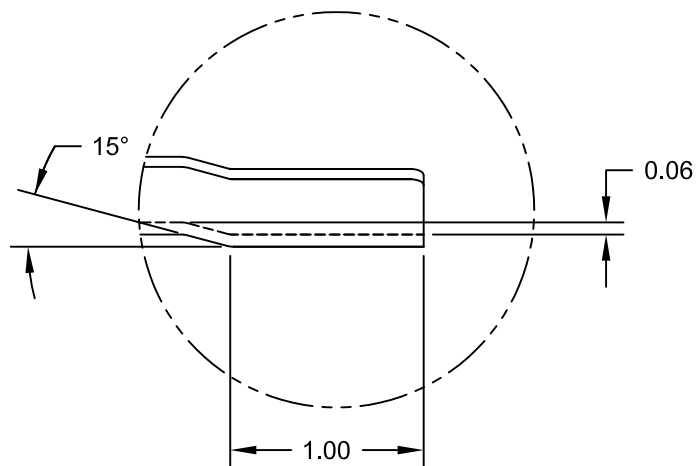
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**DETAIL A: TAB DETAIL**

SCALE 4X C3-2  
C6-3

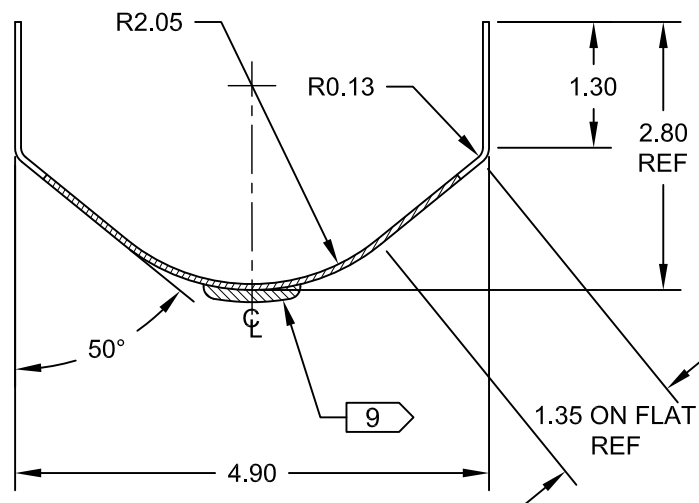


**DETAIL B: JOGGLE DETAIL**

SCALE 4X B2-2  
B6-2  
B4-3  
B7-3

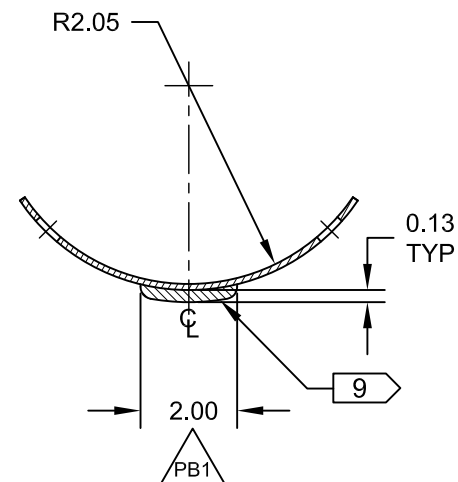
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**SECTION C-C**

SCALE 2X B5-2  
B4-3



**SECTION D-D**

SCALE 2X

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